

## ABSTRACT OF THE DISCLOSURE

A vertical machining center with a tool slide, which can be moved in a controlled manner, and a workpiece feed on one side of a machining area is designed for automatically changing the workpiece holders with workpieces. To this end, the workpiece feed is designed for holding available and accepting workpiece holders with workpieces and is mounted so as to be in alignment with a CNC rotary table on that side of the vertical machining center, on which the respective workpiece holder is held by the CNC rotary table.